

FREOPOX

Hydro-Hammer Finish WE1960

- Water based 2 component Hammer Effect Finish
- For hard and tough-elastic industrial coatings
- Only for in/outdoor usage
- Fast dry
- Containing silicon

Technical / Physical Data	Resin/ binder	epoxi dispersion, cured with polyisocyanate
	Colour	acc. to the colour shade Frei-Hammer Effect Finish other colour shades on request
	Gloss value visual	mat
	Original viscosity Haake-Viscotester 7 plus	7000 to 8000 mPa.s / Spindel 6
	Mixing ratio by weight	5 : 1
	Hardener based	FREOPOX-Hydro-Hardener HE0120 polyamin adduct
	Potlife after hardener addition	max. 5 h / 20°C end of pot life is not visible by gelation
	Density after hardener addition calculated	1,2 g / ml + / - 0,1
	Solid content after hardener addition calculated	45 % + / - 2
	Solid content in volume after hardener addition calculated	286 ml / kg + / - 10
	Consumption calculated in original viscosity after hardener addition, without application loss	130 to 140 g / m ² dry film thickness 40 µm see „Special remarks“

Storability

Approx. 6 month in original packings at an ambient temperature of 5 to 25 °C, in case the original packings are tightly closed. Protect from frost. Opened packing must be used very shortly. The minimum storage stability of each batch is mentioned on the product label. A storage time beyond the mentioned date doesn't necessarily mean that the material is unusable. In this case a check of the qualities which are important for the respective

Processing and application

Application

Components are to be mixed homogeneously (e.g. with high-speed mixer).
Application: without thinner, high thickness, wet application, 1 to 2 cross coats,
In order to avoid "fish eyes" (spots without paint) we recommend to spray first a thin layer (not completely covering the substrate) followed by a thick layer. Take care that no overspray will come into the wet surface.

spraying-airless: Pay attention to material pressure and spraying nozzle
consider the spraying pressure and nozzle!
Recommendable spraying pressure: 100 to 120 bar
nozzle: 0,33 mm till 0,38 mm (0,013 to 0,015 inch)
an adjustment for a special effect can eventually be necessary

pneumatic-spraying: supplied in a middle sized hammer effect
nozzle: 1,8 mm spraying pressure: 3 bar
spraying (atomizer) pressure: 4 to 5 bar 4 to 5 bar nozzle: 1,8 to 2,0 mm

Substrates

Steel, steel galvanized, non-ferrous metals

Pretreatment

The substrate must be free of materials which prevent adhesion, e.g. oil, grease and surfactant.
According to the requirements we recommend to apply the suited chemical (e.g. phosphatizing, chromating) or / and mechanical (e.g. shot blasting) pretreatment.

Proposal for a coating system

primer:	Recommendation for ferrous, steel as well as non ferrous materials		
	1 component:	FREIOPLAST-Hydro-Primer	WL1629
	2 component:	FREOPOX-Hydro-Primer	WE1932
top coat:	FREOPOX-Hydro-Hammer Finish		WE1960

Application temperature

above 10 °C

Drying

air drying at 20°C

dust dry:	after 20 min	(degree of drying 1/ DIN 53150)
dry to touch:	after 12 h	(degree of drying 4/ DIN 53150)
complete dry:	after 14 days	(swinging beam hardness/ ISO 1522)

oven drying: up to 100 °C possible (object temperature)

Repair coating

for repainting of completely hardened coatings use EFDEDUR-Vorlack UR1900
as an adhesion promoter, if necessary sand the substrate

Cleaning of working equipment

immediately after use: water, lightly dried material on the surface of working tools:
organic cleaners, e.g. EFD-Verdünnung 400744.

Advise for safety protection and protection of health

The usual precautionary measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

Special remarks

Test condition

All information are based on a standard climate 20/65 DIN 50014.

For the calculation of the practical consumption loss additions have to be considered.
Indications to this are the practical experience and advices given in DIN 53220.

All information are based on our product knowledge and experience. To the application we have no direct influence. For further information please don't hesitate to contact us.

The information mentioned herein are reference values and are not given as specification